

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020065**Date Inspected:** 09-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie, Lu Li Qing.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 12CW, PP116.5, Floor Beam.

During Random Visual in process Inspection, this QA inspector observed fit up of Floor beam FB3095. The attached photographs provide additional detail.

Assembly, Bay 14, 12BW, Deck plate(DP3051A) to Deck plate(DP3052A).

FCAW Repair welding of weld joint SEG3005*-008(WRR # Temporary); located on assembly, Bay 14, 12BW. Welder is identified as 201215; ZPMC Quality Control Inspector (QC) is identified as Liu Hau Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-1G(1F)-REPAIR.

Assembly, Bay 14, SEG072, 11DE.

FCAW welding of weld joint SSD16-PP104-221, 231, 220, 230; located on assembly, Bay 14, 11DE. Welder is identified as 058551; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4C-F.

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Assembly, Bay 14, 11DE, SEG072.

FCAW welding of weld joint SEG072-40, 23, 24; located on assembly, Bay 14, 11DE. Welder is identified as 055491; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-B-U2-F.

Assembly, Bay 14, Traveler rail.

During Random Visual in process Inspection, this QA inspector observed Heat straightening of traveler rails identified as 10TR3-034, 10TR3-005. The attached photographs provide additional detail.

Assembly, Bay 14, 12AE, Edge plate.

During Random Visual in process Inspection, this QA inspector observed fit up of Edge plate EP3004A. The attached photographs provide additional detail.

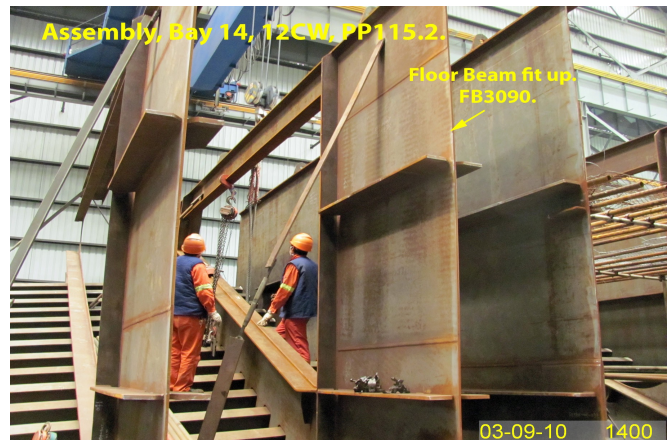
Assembly, Bay 14, 12CW, PP115.2, Floor Beam.

During Random Visual in process Inspection, this QA inspector observed fit up of Floor beam FB3090. The attached photographs provide additional detail.

Training for Phased Array Ultrasonic Testing.

This QA inspector attended Training for Phased Array Ultrasonic Testing (PAUT) from 1600Hrs. to 1900Hrs.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Juvekar,Amit

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer